

Work Order ID 83406

Apr 17 12:25 PM

\*83406\*

Page 1

Item ID: D206-642-541

Revision ID:

Item Name: Replacement Skidtube

Start Date: 17/04/2012 Start Qty: 1.00

Required Date: 26/04/2012 Req'd Qty: 1.00

Reference:

\*1\*

\*1\*

\*N9000040100\*

Cust Item ID:

Customer:

Setup Start \*NS1\*

Stop \*NS2\*

Approvals: Process Plan: MCT  
QC:

Date: 12/04/17 Tooling:

Date: SPC (Y/N):

Date:

Date:

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/  
Work Center ID Operation  
Description

Draw Nbr Revision Nbr

D3274 D

100  
\*100\*

DC  
Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile & type label for Part D206-642-541

CHG003

SCRAP

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Work Order ID 83406

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Page 2

April-17-12 4:10:25 PM

Item ID: D206-642-541

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Replacement Skidtube

Start Date: 17/04/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 26/04/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Run Start

\*NR1\*

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

\*NR2\*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

110

0.00

\*110\*

Skidtubes

Skidtubes

Memo

0.00

\*\*\*VERIFY AND INSPECT THE MATERIAL PRIOR TO USE!\*\*\*

1- Bend FWD end of tube using bend prog D3274 FWD and foil 10 as per dwg D3274, cut fwd end of tube with saw table setup D3274.

2- remove fwd indexing ridge as per dwg D3274. Prepare for welding

3- weld fwd cap as per dwg D3274 and QSI004

AR Aluminum Rod Batch: M120164/M120854

4- grind fwd cap weld on top surface only

5- Cut AFT end of tube at 170.9" as per dwg D3274 and deburr end.

6- Drill Aft cap pilot hole using DT8025

7- Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D. Drill 3/16" pilot holes as per Dwg D3274

8- Remove inner indexing ridge on aft end of skidtube as per Dwg D3274 scribe batch #

9- Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

31.1 12.06.16  
3/16 12-5-16  
802-05 16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Item ID: D206-642-541

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Replacement Skidtube

Stop \*NS2\*

Start Date: 17/04/2012 Start Qty: 1.00 \*1\*

Required Date: 26/04/2012 Req'd Qty: 1.00 \*1\*

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start \*NR1\*

QC: Date:

SPC (Y/N): Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

114

QC5- Inspect part completeness to step on W/O

0.00

\*114\*

QC

Memo

0.00

Quality Control

116

QC10- Inspect visual per QSI004- ground welds

0.00

\*116\*

QC

Memo

0.00

Quality Control

120

Chemical Conversion Coat per QSI005 4.1

0.00

\*120\*

HandFinish

Memo

0.00

Hand Finishing

CLK 12-5-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 4

Item ID: D206-642-541

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Replacement Skidtube

Stop

**\*NS2\***

Start Date: 17/04/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 26/04/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC7-Inspect Chemical Conversion Coat

0.00

**\*130\***

QC

Memo

0.00

Quality Control

① SAN 12 05 22

150

Skidtubes

0.00

**\*150\***

Skidtubes

Memo

0.00

Skidtubes

1-Open Ø0.313" and 0.375" crossbolt spacer holes as per Dwg D3274

2-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube

3-Bond web in place as per Dwg D3274 & QSI 015.

A/RSikaflex-291 12/22/1

Sikaflex expire date: 13/01/04

Start: 12/05/22 Time: 4:15

Finish: \_\_\_\_\_ Time: \_\_\_\_\_

(Adhere for 12 hours)

> 1 X CF 12 5 22

- DE 12/05/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Reference:

Accept

\*N9000040100\*

Setup Start \*NS1\*

Stop \*NS2\*

Cust Item ID:

Customer:

Approvals: Process Plan: Date:

QC: Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/  
Work Center ID

160

\*160\*

QC

Quality Control

Operation  
Description

QC5- Inspect part completeness to step on W/O

Memo

Set Up/  
Run Hours

0.00

0.00

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

DD

12-5-23

170

\*170\*

Skidtubes

Skidtubes

Skidtubes

Memo

1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt spacer holes to maintain web position.

2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2  
OPEN HOLES TO .297" . Deburr

3-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD  
END OF TUBE  
DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES)  
REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES

4- Countersink crossbolt spacer holes as per Dwg D3274

5- prepare for welding

DD 12-5-23

PTO

## WORK ORDER CHANGES

W/O: <u>438010</u>		WORK ORDER CHANGES					Approval	
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: D206042 4/1 PAR #: \_\_\_\_\_ Fault Category: skid tube NCR: Yes No DQA: 12/7/24 Date: 12/07/24  
 Resolution: \_\_\_\_\_ Disposition: General QA: N/C Closed: ✓ Date: 12/7/24

WORK ORDER NON-CONFORMANCE (NCR) 11032.75

NCR: <u>12-1608</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>12-5-23</u>	<u>170</u>	<u>Found after handling that employee had drilled the Taw ring hole at the wrong place</u>	<u>✓</u> <u>12-7-18</u>	<u>Script &amp; destroy</u>	<u>CF</u> <u>12-7-18</u>	<u>DP</u> <u>12-7-18</u>	<u>12-7-18</u>	<u>DAS</u> <u>12/6/24</u>
		<u>RC, lack of attention</u> <u>- Did not read w/p</u> <u>- Did not read drawing</u> <u>- Missed at inspection</u>						

NOTE: Date &amp; initial all entries

# Work Order ID 83406

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\*83406\*

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Item ID: D206-642-541

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Replacement Skidtube

Start Date: 17/04/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 26/04/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

180

QC5- Inspect part completeness to step on W/O

0.00

\*180\*

QC

Memo

0.00

Quality Control

190

0.00

\*190\*

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod A/RAluminum Rod \_\_\_\_\_

3-Grind cross bolt welds flush as per Dwg D3274.

4-Counterbore 5/16" x 0.750" deep as per Dwg D3274 and deburr.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 83406****\*83406\***

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Item ID: D206-642-541

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Replacement Skidtube

Start Date: 17/04/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 26/04/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	--------------	---------------	---------------	------------------	----------------

200

QC5- Inspect part completeness to step on W/O

0.00

**\*200\***

QC

Memo

0.00

Quality Control

210

QC10- Inspect visual per QSI004- ground welds

0.00

**\*210\***

QC

Memo

0.00

Quality Control

220

Pressure Wash per QSI005 4.3

0.00

**\*220\***

HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Work Order ID 83406

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**\*83406\***

Page 8

Item ID: D206-642-541

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Replacement Skidtube

Start Date: 17/04/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 26/04/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

230

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

**\*230\***

Powdercoat

Memo

0.00

Powder Coating

START TIME: \_\_\_\_\_

OVEN TEMPERATURE: \_\_\_\_\_

FINISH TIME: \_\_\_\_\_

240

QC3- Inspect Part Finish

0.00

**\*240\***

QC

Memo

0.00

Quality Control

250

HandFinishing

0.00

**\*250\***

HandFinish

Memo

0.00

Hand Finishing

1-Install Nut Plate as per Dwg D3274. Apply LPS-3 to Nut Plate and rivets.  
A/RN/ALPS-3 \_\_\_\_\_

2-Install inserts as per Dwg D3274. Use a drop of Sikaflex inside insert holes a  
A/RSikaflex-291 \_\_\_\_\_  
Sikaflex expire date: \_\_\_\_\_

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries



# Work Order ID 83406

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Item ID: D206-642-541

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Replacement Skidtube

Stop \*NS2\*

Start Date: 17/04/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 26/04/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

260

QC5- Inspect part completeness to step on W/O

0.00

\*260\*

QC

Memo

0.00

Quality Control

Inspect Nut Plate & Inserts

270

0.00

\*270\*

HandFinish

HAND FINISHING RESOURCE #1

Memo

0.00

Hand Finishing

1-Install wearpads & gaskets as per Dwg D3274.

2-Install ring as per Dwg D3274

A/RSikaflex-291

Sikaflex expire date:

3-Inspect for foreign objects as per QSI 024

4-Spray inside of tube on both sides of web with LPS-3

A/R LPS-3

Batch:

5-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.

A/RSikaflex-291

Sikaflex expire date:

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

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**\*8.3406\***

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Item ID: D206-642-541

Revision ID:

Item Name: Replacement Skidtube

Start Date: 17/04/2012 Start Qty: 1.00

Required Date: 26/04/2012 Req'd Qty: 1.00

Reference:

**\*1\***

**\*1\***

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Stop **\*NS2\***

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

280

**\*280\***

QC

Quality Control

Operation  
Description

QC5- Inspect part completeness to step on W/O

Set Up/  
Run Hours

0.00

Memo

0.00

290

**\*290\***

Packaging

Packaging

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00

Memo

0.00

300

**\*300\***

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

*WF*  
*12-07-19*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

## Picklist Print

April-17-12 4:10:29 PM

Work Order ID: 83406

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

\*83406\*

\*D206-642-541\*

Start Date: 17/04/2012

Required Date: 26/04/2012

Start Qty: 1.00

Required Qty: 1.00

## Comments:

IPP Rev: B05.09.23 Revised per D206-642 Rev. JKJ/JLM  
 IPP Rev: C 07-02-23 Added SS Wearplates & Gaskets JLM  
 IPP Rev: D 07-12-06 replace NAS1515H3L to D3672-1 DD  
 IPP Rev: E 08-04-17 as per PAR 08-015 DD verified by: EC  
 IPP Rev: F 08-06-02 add comment DD verified by: EC  
 IPP Rev: G 08-10-09 revise details DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2600-1-190

\*D2600-1-190\*

Extrusion Round 3" 206

Manufactured No

110 Each 114.0000

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Location	Loc Qty	Loc Code
----------	---------	----------

HALL

45

69622

45

LG

69

76912

69

D3285-1

\*D3285-1\*

Cap

Manufactured No

110 Each 49.0000

\*\*

Location	Loc Qty	Loc Code
----------	---------	----------

LG002

49

52511

3

52647

46

D3282-041

\*D3282-041\*

Float Web (206L/407)

Manufactured No

150 Each 7.0000

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Location	Loc Qty	Loc Code
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LG

7

77498

1

80837

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

April-17-12 4:10:29 PM

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Work Order ID: 83406

\*83406\*

Parent Item: D206-642-541

\*D206-642-541\*

Parent Item Name: Replacement Skidtube

Start Date: 17/04/2012

Required Date: 26/04/2012

Start Qty: 1.00

Required Qty: 1.00

D2649

Manufactured No

190

Each

1,060.000

12

12

\*D2649\*

\*\*

Cross Bolt Spacer

## Location

## Loc Qty

## Loc Code

LG

721

77574

2

79502

65

79503

399

79564

248

79565

7

LG001

339

65317

1

68224

2

68507

11

71355

2

72704

2

72841

11

73390

8

73857

21

73858

53

73859

4

73860

4

78020

6

78583

2

79566

212

D3275-1

Manufactured No

190

Each

153.0000

12

12

\*D3275-1\*

\*\*

Crossbolt Spacer

## Location

## Loc Qty

## Loc Code

LG

103

80184

103

LG002

50

66930

46

74437

4

April-17-12 4:10:29 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



# Picklist Print

April-17-12 4:10:29 PM

Work Order ID: 83406

\*83406\*

Parent Item: D206-642-541

\*D206-642-541\*

Parent Item Name: Replacement Skidtube

Start Date: 17/04/2012

Required Date: 26/04/2012

Start Qty: 1.00

Required Qty: 1.00

CR3212-4-03

Purchased

No

250

Each

1,382.000

2

2

\*CR3212-4-03\*

\*\*

Cherry Rivet

Location

Loc Qty

Loc Code

FP002

394

114859

394

ST331

988

110139

2

119017

986

D3415-041

Manufactured

No

250

Each

14.0000

1

1

\*D3415-041\*

\*\*

Nut Plate

Location

Loc Qty

Loc Code

ST042

14

67605

14

CCR264SS3-3

Purchased

No

250

Each

467.0000

2

2

\*CCR264SS3-3\*

\*\*

Cherry Rivet

Location

Loc Qty

Loc Code

ST331

467

113973

2

117849

109

119017

356

April-17-12 4:10:29 PM

Shop Packet Print

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

April-17-12 4:10:29 PM

Page 4

Work Order ID: 83406

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

\*83406\*

\*D206-642-541\*

Start Date: 17/04/2012

Required Date: 26/04/2012

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-130

Purchased

No

250

Each

5,643.000

78

78

**\*AI S4-1032-130\***

Insert

\*\*

Location

Loc Qty

Loc Code

ST280

205

119084

116

120671

89

ST281

2438

120807

438

120837

2000

ST282

3000

121269

3000

D3536-15

Manufactured

No

270

Each

34.0000

1

1

**\*D3536-15\***

Gasket

\*\*

Location

Loc Qty

Loc Code

FP002

34

73318

16

80333

4

81343

14

D3536-23

Manufactured

No

270

Each

17.0000

1

1

**\*D3536-23\***

Gasket

\*\*

Location

Loc Qty

Loc Code

FP002

17

74510

1

80334

16

April-17-12 4:10:29 PM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

April-17-12 4:10:29 PM

Page 5

Work Order ID: 83406

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

\*83406\*

\*D206-642-541\*

Start Date: 17/04/2012

Required Date: 26/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3536-35

Manufactured No

270

Each

43.0000

1

1

\*D3536-35\*

Gasket

\*\*

Location

Loc Qty

Loc Code

FP002

43

80335

7

81340

12

82065

24

D3536-39

Manufactured No

270

Each

24.0000

1

1

\*D3536-39\*

Gasket

\*\*

Location

Loc Qty

Loc Code

FP

12

82252

12

FP002

12

73317

12

D3535-15

Manufactured No

270

Each

31.0000

1

1

\*D3535-15\*

Wearshoe

\*\*

Location

Loc Qty

Loc Code

FP001

31

74512

6

80328

12

81354

13

April-17-12 4:10:29 PM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES.					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

April-17-12 4:10:29 PM

Page 6

Work Order ID: 83406

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

**\*83406\***

**\*D206-642-541\***

Start Date: 17/04/2012

Required Date: 26/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3535-35

Manufactured No

270

Each

40.0000

1

1

**\*D3535-35\***

Wearshoe

**\*\***

Location

Loc Qty

Loc Code

FP001

40

67598

1

70815

1

78873

13

79849

1

81358

9

82064

15

D3535-39

Manufactured No

270

Each

18.0000

1

1

**\*D3535-39\***

Wearshoe

**\*\***

Location

Loc Qty

Loc Code

FP001

18

69759

1

73316

5

74513

12

D3535-23

Manufactured No

270

Each

11.0000

1

1

**\*D3535-23\***

Wearshoe

**\*\***

Location

Loc Qty

Loc Code

FP001

11

74508

1

80330

10

April-17-12 4:10:29 PM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



# Picklist Print

April-17-12 4:10:29 PM

Page 7

Work Order ID: 83406

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

\*83406\*

\*D206-642-541\*

Start Date: 17/04/2012

Required Date: 26/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3537-3

Manufactured No

270

Each

29.0000

1

1

\*D3537-3\*

Wearpad

\*\*

Location

Loc Qty

Loc Code

FP002

29

78836

24

80338

5

D3537-1

Manufactured No

270

Each

103.0000

9

9

\*D3537-1\*

Wearpad

\*\*

Location

Loc Qty

Loc Code

FG

10

79833

10

FP002

93

69817

5

73716

82

80337

4

81361

2

AN960C10L

NAS1149C0332  
R

Purchased

No

270

Each

0.0000

80

80

\*AN960C10L \*

washer

\*\*

AN960C416

NAS1149C0463  
R

Purchased

No

270

Each

0.0000

1

1

\*AN960C416\*

washer

\*\*

April-17-12 4:10:29 PM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Shop Packet Print**

April-17-12 4:10:29 PM

Work Order ID: 83406

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

Page 8

**\*83406\***

**\*D206-642-541\***

D3672-1

**\*D3672-1\***

Phenolic Washer

Manufactured No

Start Date: 17/04/2012

Start Qty: 1.00

Required Date: 26/04/2012

Required Qty: 1.00

270 Each 1,010.000 2 2

\*\*

Location

Loc Qty

Loc Code

FP001

66821

34

ST060

34

72229

976

76277

4

80369

472

500

Purchased No

270 Each

2,818.000

80

80

\*\*

Location

Loc Qty

Loc Code

ST350

120187

2818

120521

1752

120769

28

121205

38

1000

Purchased No

270 Each

235.0000

\*\*

Location

Loc Qty

Loc Code

ST355

112243

235

119017

152

83

Shop Packet Print

Page 8

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

April-17-12 4:10:29 PM

Page 9

Work Order ID: 83406

**\*83406\***

Parent Item: D206-642-541

**\*D206-642-541\***

Parent Item Name: Replacement Skidtube

Start Date: 17/04/2012

Required Date: 26/04/2012

Start Qty: 1.00

Required Qty: 1.00

D2646

Manufactured

No

270

Each

75.0000

1

1

**\*D2646\***

**\*\***

Aft Cap

Location

Loc Qty

Loc Code

FP002

75

62678

5

68280

5

70945

1

71070

2

73294

1

73825

2

78018

17

79500

1

79562

41

D3413-1

Manufactured

No

270

Each

48.0000

1

1

**\*D3413-1\***

**\*\***

Ring

Location

Loc Qty

Loc Code

ST420

16

79233

16

ST464

32

76754

22

80224

10

April-17-12 4:10:29 PM

Shop Packet Print

Page 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN CP	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED #	APPROVED #	DRAWING NO. D3274	REV. D SHEET 1 OF 4
DATE 06.12.19		TITLE SKIDTUBE ASSEMBLY SCALE NTS	
A	04.03.15	NEW ISSUE	
B	04.08.09	MOVE SADDLE HOLE: 42.14 WAS 42.76	
C	05.03.16	ADD -043; NEW INSERTS	
D	06.12.19	NEW INSERTS, SS WEARSHOE + GASKET	

RELEASED

07.02.12

DEO ATTACHED

Qty -041	Qty -043	Part Number	Description
X		D3274-041	SKIDTUBE ASSEMBLY
	X	D3274-043	SKIDTUBE ASSEMBLY
1	1	D2600-1-240	EXTRUSION
1	1	D2646	AFT CAP
12	12	D2649	CROSS BOLT SPACER
12	37	D3275-1	CROSS BOLT SPACER
1	1	D3282-041	FLOAT WEB
1	1	D3285-1	CAP
1	1	D3413-1	RING
1	1	D3415-041	NUT PLATE
1	1	D3535-15	WEARSHOE
1	1	D3535-23	WEARSHOE
1	1	D3535-35	WEARSHOE
1	1	D3535-39	WEARSHOE
1	1	D3536-15	GASKET
1	1	D3536-23	GASKET
1	1	D3536-35	GASKET
1	1	D3536-39	GASKET
9	9	D3537-1	WEARPAD
1	1	D3537-3	WEARPAD
78	78	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
80	80	AN3C4A	BOLT
1	1	AN4C5A	BOLT
1	1	AN960C416	WASHER
80	80	AN960C10L	WASHER
2	2	CCR264SS3-3	RIVET
2	2	CR3212-4-03	RIVET
2	2	NAS1515H3L	WASHER

GENERAL NOTES:

1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. DAMAGE TOLERANCE ON FWD BEND:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
3. ALL HOLES DRILLED ON CENTERLINES.
4. BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINISH: - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1  
- POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
7. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
8. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

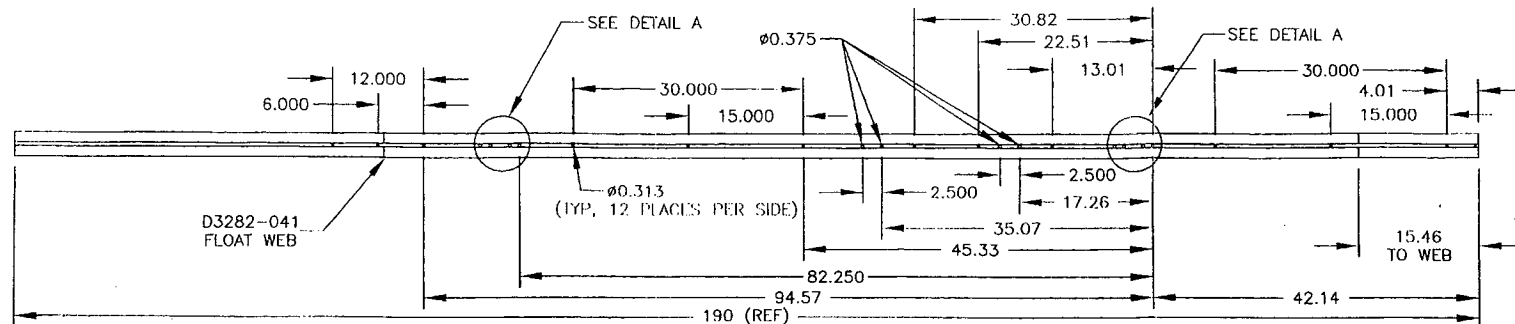
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

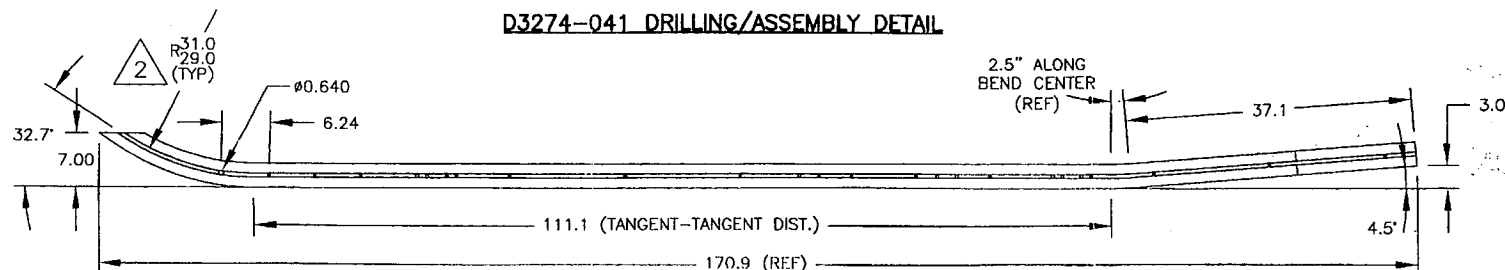
NOTE: Date & initial all entries



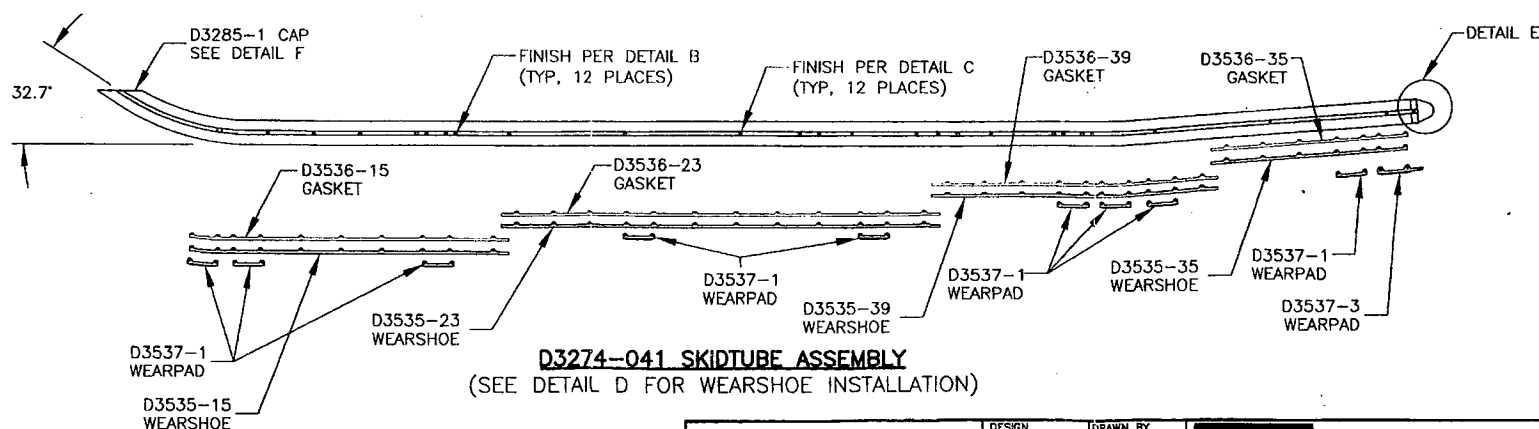
DEO ATTACHED



**D3274-041 DRILLING/ASSEMBLY DETAIL**



**D3274-041 BEND/DRILLING DETAIL**



**D3274-041 SKIDTUBE ASSEMBLY**  
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

RELEASED

07.02.12

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DESIGN

CP

DRAWN BY

PH

**DART** DART AEROSPACE USA, INC.  
PORT HADLOCK, MA

CHECKED

A

APPROVED

A

DRAWING NO.

D3274

REV. D

DATE

06.12.19

TITLE

SKIDTUBE ASSEMBLY

SCALE

1:15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

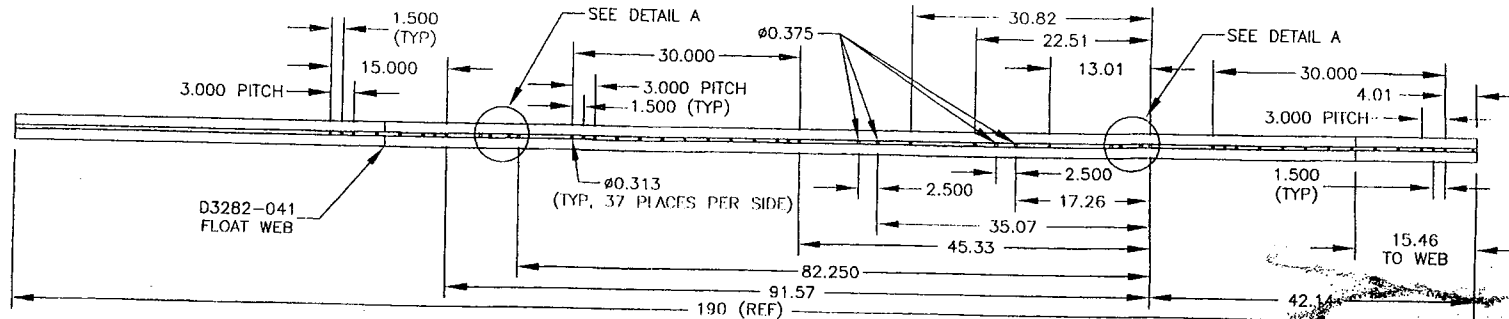
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

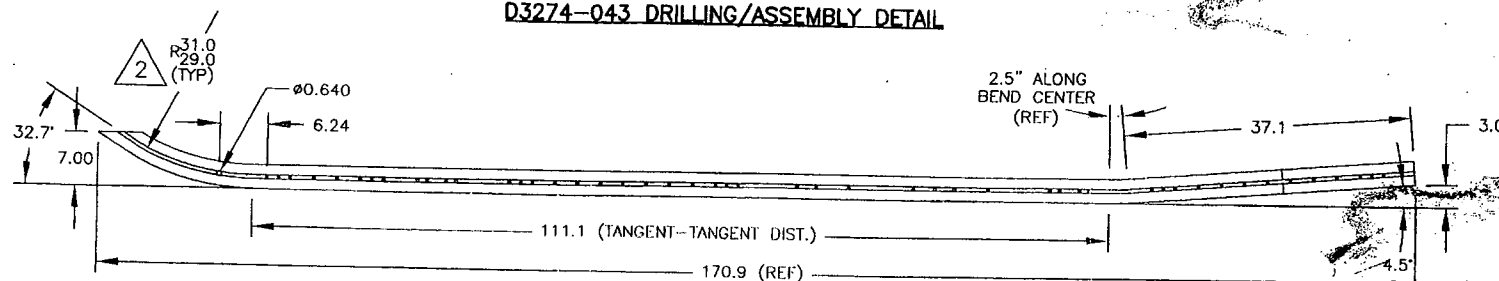
**NOTE:** Date & initial all entries

83406

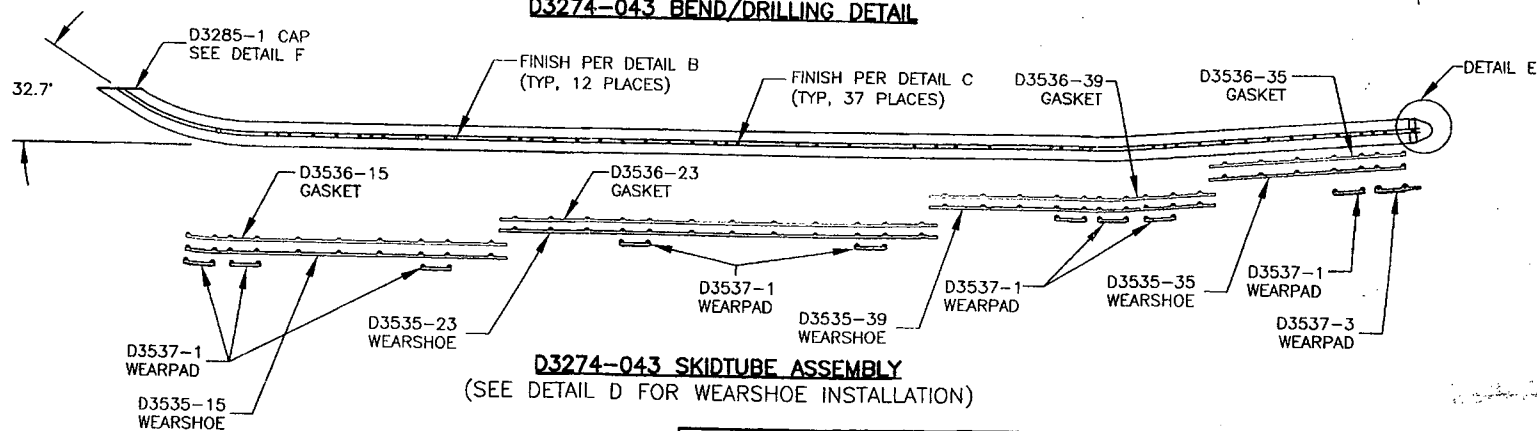
DEO ATTACHED



D3274-043 DRILLING/ASSEMBLY DETAIL



D3274-043 BEND/DRILLING DETAIL



D3274-043 SKIDTUBE ASSEMBLY

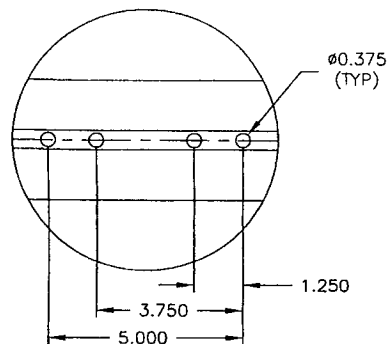
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

RELEASED

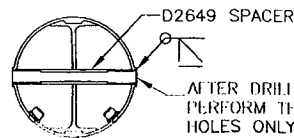
07.02.12

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		DATE	06.12.19	TITLE		D3274	SHEET 3 OF 4
				SKIDTUBE ASSEMBLY			SCALE 1:16

# **DETAIL A: DRILL DETAIL**

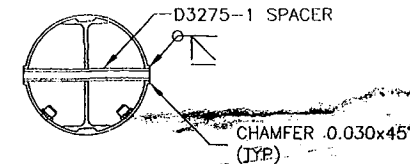


## **DETAIL B** FOR 0.375 HOLES ONLY

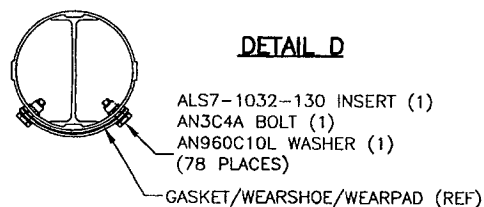


AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR 0.375  
HOLES ONLY:  
1. CHAMFER HOLE 0.030x45°  
2. INSERT D2649 SPACER  
3. WELD INTO PLACE AND GRIND FLUSH  
4. C'BORE TO 0.313x0.75 DEEP

## **DETAIL C** FOR 0.313 HOLES ONLY



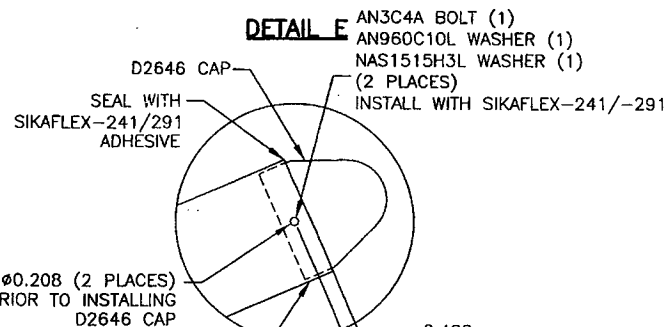
## **DETAIL D**



ALS7-1032-130 INSERT (1)  
AN3C4A BOLT (1)  
AN960C10L WASHER (1)  
(78 PLACES)

GASKET/WEARSHOE/WEARPAD (REF)

## **DETAIL E**



AN3C4A BOLT (1)  
AN960C10L WASHER (1)  
NAS1515H3L WASHER (1)  
(2 PLACES)  
INSTALL WITH SIKAFLEX-241/-291

D2646 CAP

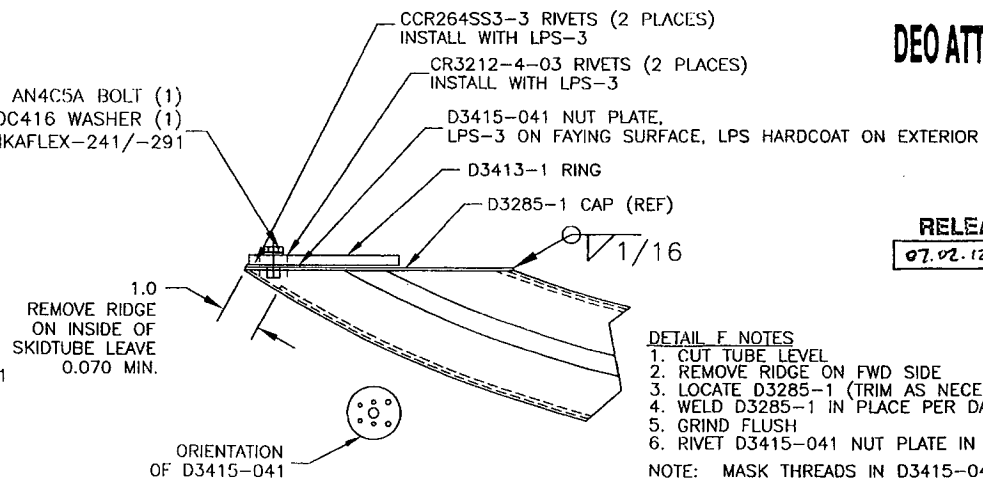
SEAL WITH  
SIKAFLEX-241/291  
ADHESIVE

0.208 (2 PLACES)  
DRILL PRIOR TO INSTALLING  
D2646 CAP

BORE OUT END OF SKIDTUBE  
TO 0.75 DEPTH AND 0.070 WALL

0.400

## **DETAIL F: END FINISHING DETAIL**



CCR264SS3-3 RIVETS (2 PLACES)  
INSTALL WITH LPS-3

CR3212-4-03 RIVETS (2 PLACES)  
INSTALL WITH LPS-3

D3415-041 NUT PLATE,  
LPS-3 ON FAYING SURFACE, LPS HARDCOAT ON EXTERIOR

D3413-1 RING

D3285-1 CAP (REF)

1/16

1.0  
REMOVE RIDGE  
ON INSIDE OF  
SKIDTUBE LEAVE  
0.070 MIN.

ORIENTATION  
OF D3415-041

**DEO ATTACHED**

**RELEASED**

07.02.12

## **DETAIL F NOTES**

1. CUT TUBE LEVEL
  2. REMOVE RIDGE ON FWD SIDE
  3. LOCATE D3285-1 (TRIM AS NECESSARY)
  4. WELD D3285-1 IN PLACE PER DART QSI 004
  5. GRIND FLUSH
  6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041  
PRIOR TO FINISH

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DESIGN	CP	DRAWN BY	PH	<b>DART</b> DART AEROSPACE USA, INC. FORT HADLOCK, MA	REV. D
CHECKED	#	APPROVED	#	DRAWING NO. D3274	SHEET 4 OF 4
DATE	06.12.19	TITLE	SKIDTUBE ASSEMBLY	SCALE	1:3

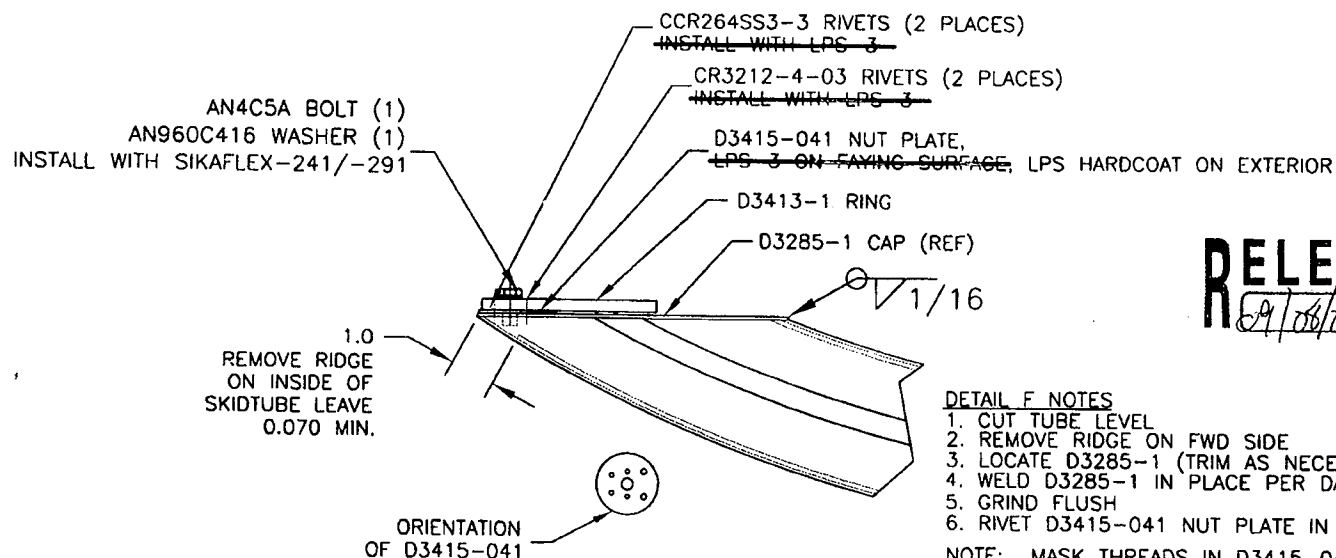
DRAWING NO. D3274	TITLE SKIDTUBE ASSEMBLY	REV. D	<b>DART AEROSPACE USA, INC</b>	D.E.O. NO. D3274-D-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>CP</i>	CHECKED <i>1</i>	MFG. APPR. <i>AA</i>	APPROVED <i>MP</i>	DE APPR. <i>#</i>		
DATE 09.06.17	DATE 09.06.23	DATE 09/06/23	DATE 09/06/23	DATE 09.06.23		

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF SKIDTUBE.

AMEND NOTE 8: ~~"SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES 'LPS-3' AFTER FINISH AND INSTALLATION OF INSERTS.~~  
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES 'LPS PROCYON' AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF  
POWDER COATING WITH MEK DEGREASER."

AMEND DETAIL F AS SHOWN:

### DETAIL F: END FINISHING DETAIL



#### DETAIL F NOTES

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D3415-041  
PRIOR TO FINISH

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